



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C3-12-4

Job Sheet 177503



Part No: C3-12-4

Job Qty: 40 ea

Part Name: Lock Roller



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/14/18

Job Tracking No:

Due Date: 6/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG C3-12-4 Rev. 1A IPP Rev. A 18.04.19 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		6/28/18	0.00	0.00	Start Up Machining-4		14-8-9 JBD
120	CNC Lathe	40 pcs		6/28/18	1.00	4.00	MORI SL-154		14-8-9 JBD
130	QC	40 pcs		6/28/18	0.00	0.00	QC2 Machining-5		15-08-09
140	QC	40 pcs		6/28/18	0.00	0.00	QC8 Machining-5		15-08-09
150	Outsource	40 pcs		6/28/18	0.00	0.00	Outsource1		15-08-10
180	Outsource	40 pcs		6/28/18	0.00	0.00	Outsource15		
190	Packaging	40 pcs		6/28/18	0.00	0.00	Packaging2		AUG 2 3 2018
200	QC	40 pcs		6/28/18	0.00	0.00	QC6		38
210	Packaging	40 pcs		6/28/18	0.00	0.00	Packaging3		9-89
220	QC21-SA	40 Ea		6/28/18	0.00	0.00	QC21		21 AUG 2 3 2018

Part Op 120 - 1-Machine as per folio FC097 FOLIO REV: _____ DWG REV: _____ 2-Debur

Descriptions: 150 - 1--Issue P/O to Metcore ; P/O 040-17 RC 53-56 2-Bead blast 3- Certificate of Conformity is required

NOTE DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech or ATG***

180 - -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-
.0006 - Certificate of Conformity is required

190 - Receive

210 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140H-R0.750	4140 Round Bar .750	1.6400 ft (.041 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140H-R0.750	2	13	0

Part Specifications

Specifications could not be found.

AND A 3016

1008 10 10/10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

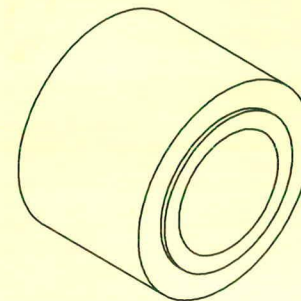
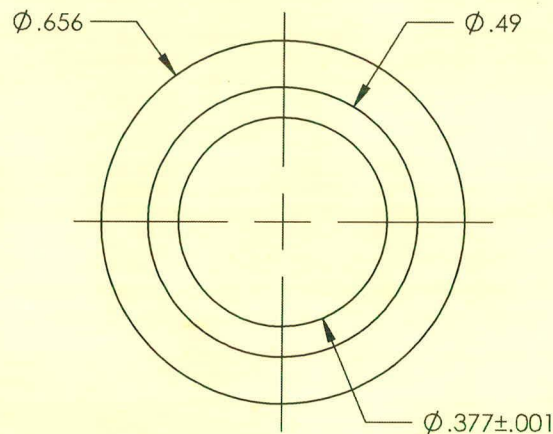
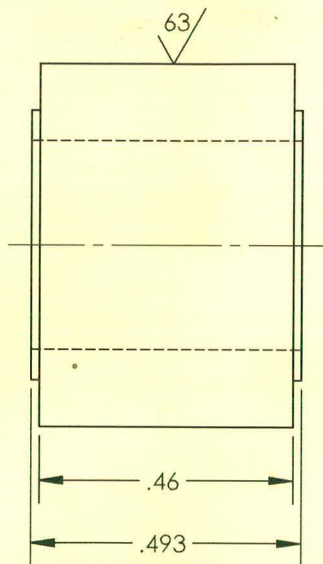
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____		Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 09/09/18 Container No: S100620 Part: C3-12-4 Job No: 177503 Serial No/Batch: S100620 Revision: 1A Inspector: _____ Exp Date: _____ Instructions: _____																					
Description Work Order																									
				MRB (QSI042) Approval																					
				Completed By																					
				Lead hand / Supervisor Approval Verification																					
				QC / QA Coordinator Approval																					
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>				Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> P ☐ B ☐ C ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>				P ☐ B ☐ C ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:50%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>		Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐										
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OTHER : _____																									

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1A	14-0111	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED NOTE 2. ADDED NOTE 3 AND CORRECTED NICKEL PLATE THICKNESS WAS .0005 IS .0004-.0006. CH'D DIMENSION TOLERANCE WAS .463 IS .46, WAS Ø.487 IS Ø.49. CH'D DIMENSION WAS Ø.380 IS Ø.377 ±.001.	8/7/2014	DJN
				RW



NOTES:

1. POLISH OD AFTER HEAT TREAT.
2. BAG & LABEL WITH BATCH NUMBER.
3. NICKEL PLATE .0004-.0006 BAKE AFTER PLATING.

DART AEROSPACE	
TITLE LOCK ROLLER	
DWG NO. C3-12-4	REV 1A
MAT'L 4140	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i> HEAT TREAT RC 53-56 FINISH SEE NOTE 3
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 3:1	DATE 11/1/2001
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			C3-12-4	1	LOCK ROLLER	4140	Ø11/16 X 5/8	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040778**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040778
PO Date: 8/20/18
Due Date: 8/23/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177503	C3-12-4	Lock Roller -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ- N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required	Firmed	-	8/23/18	39 pcs	0 pcs	39 pcs	\$6.1538467/pcs	\$240.00

39x AUG 23 2018

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Line Item Note ** BIG RUSH **

Grand Total: \$240.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/20/18 1:49 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(011946-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

011946 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
22-Aug-2018		Aman			040778				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir / Back Order
1	C3-12-4 Rev.	C3-12-4 NICKEL PLATE QQ-N-290 CLAS 2 GRADE E 0.0004-0.0006	E-NICKEL STEEL CH	39	39	0	0	0	

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

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